Work Order ID 65191

Friday, January 07, 2011 10:40:25 AM

Item ID: D3508-13 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Wearplate

Start Date: 1/7/2011 **Start Qty:** 6.00 **Cust Item ID:**

Required Date: 1/14/2011 **Req'd Qty:** 6.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** 11-01-7 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3508	Rev C								
100		0.00							
Waterjet	FLOW WATER JET					HB 11-1-10			
	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3508 ☐Dwg Rev: C ☐Prog Rev: L ☐2-								
304 .040	Deburr if necessary								
							(6)		
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC						HB 11-1-10			
	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
QC		Sulolko				(x6)			
	Memo	0.00							
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC Brake NC	NC BRAKE **Memo** 1-Form on brake using DT8326 and DT8261as per Dwg D3508	0.00 0.00	SB 11/01/11			6			
140 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00	S 11/01/11			x6			
150 Large Fab Large Fab	Large Fab **Memo** Weld hardcoat as per dwg D3508 QSI004□Hardcoat 2059b Batch: M 116468	0.00 0.00				CL 11-1-13			x6

Dart Aerospace Ltd

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC10- Inspect visual per QSI004- ground welds **Memo**	0.00 0.00							
170 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00				+6			
180 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 M112588 **Memo** START TIME: 8:10 ☐OVEN TEMPERATURE: 320 ☐FINISH TIME: 8:40.	0.00 0.00				6	BR 11-01-14.		

Dart Aerospace Ltd

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H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 65191

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Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC3- Inspect Part Finish	0.00							
QC						6	0		11/01/11
Quality Control	**Memo**	0.00							
200	Identify as per dwg & Stock Location FP16	0.00							
Packaging									
Packaging	**Memo**	0.00							
210	QC21- Final Inspection - Work Order Release	0.00							11/01/17
QC									
Quality Control	**Memo**	0.00							

11-01-17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Friday, January 07, 2011 10:40:30 AM

Work Order ID: 65191

Parent Item: D3508-13

Parent Item Name: Wearplate

Start Date: 1/7/2011 **Required Date:** 1/14/2011

Start Qty: 6.00 **Required Qty:** 6.00

Comments: IPP Rev:A New Issue 07.06.12 EC
IPP Rev:B Rev C dwg 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 304/316 .040 Sheet		Purchased	No			100	sf	181.0714	0.172	1.086316 B11-1-10			

Location		Loc Qty	Loc Code
MAT		178.3	
	115762	10.2	
	115953	11.1	
	116437	157	116437
MAT20		2.7714	
	113062	1.398	
	115440	1.3734	

6

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

DART AEROSPACE LTD	Work Order:	65191
Description: Wearplate	Part Number:	D3508-13
Inspection Dwg: D3508 **Rev:** C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
8.38	+/-0.030	8.38	✓		T B01	
5.625	+/-0.010	5.623	✓		V B02	
0.375	+/-0.010	.373	✓		V	
2.813	+/-0.010	2.810	✓		V	
2.063	+/-0.010	2.060	✓		V	
Ø0.187	+0.005/-0.001	.190	✓		V	
0.300	+/-0.010	.301	✓		V	
0.300	+/-0.010	.302	✓		V	

Measured by:	IB
Date:	11-1-10

Audited by:	S
Date:	11/01/10

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.23	New Issue	KJ/EC/DD	

Dart Aerospace Ltd

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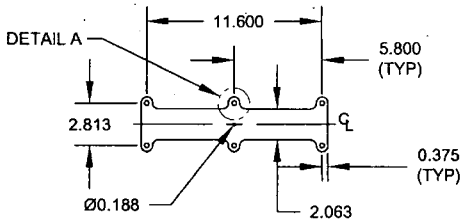
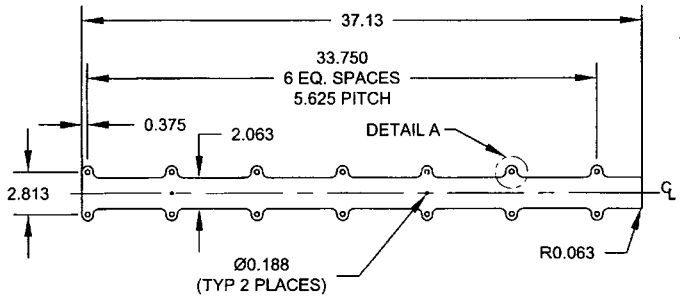


D3508-1 FLAT PATTERN



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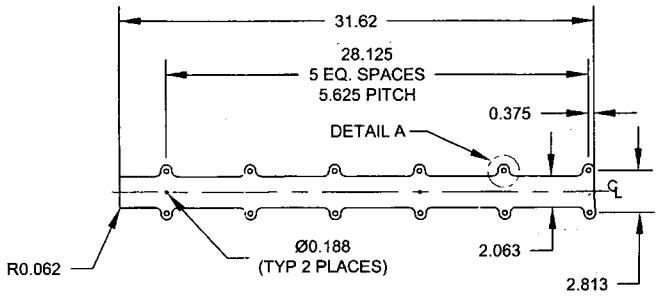
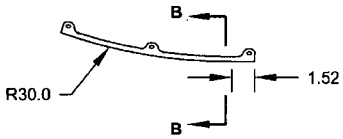
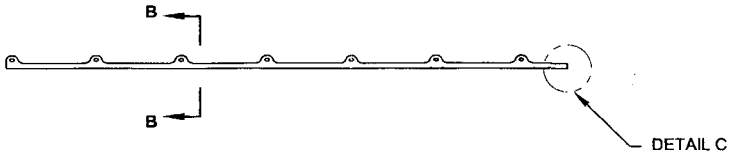


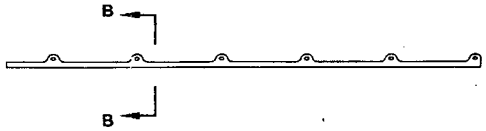
D3508-5 FLAT PATTERN



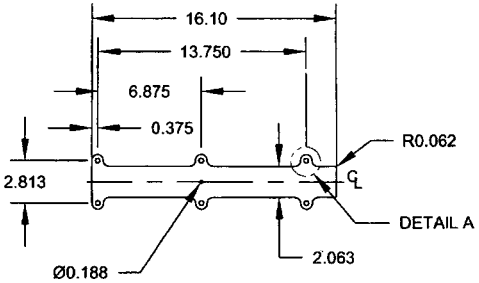
D3508-1 BENDING DETAIL
(MAKE FROM D3508-1F)



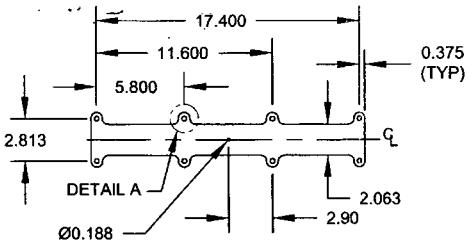
D3508-3 BENDING DETAIL
(MAKE FROM D3508-3F)



D3508-5 BENDING DETAIL
(MAKE FROM D3508-5F)



D3508-7F FLAT PATTERN

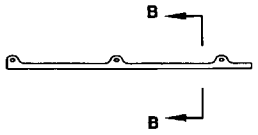


D3508-9F FLAT PATTERN

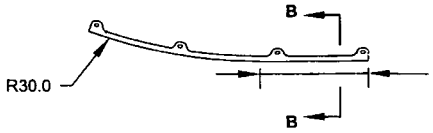
NOTES:

1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF. DART MATERIAL SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
3) WELD PER DART QSI 004
4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005 TO 0.015
7) IDENTIFICATION: NONE
8) WEIGHT: D3508-1 - 0.47 lbs, D3508-3 - 0.95 lbs, D3508-5 - 0.77 lbs, D3508-7 - 0.39 lbs, D3508-9 - 0.45 lbs, D3508-11 - 0.64 lbs D3508-13 - 0.25 lbs

RELEASED
07.11.16



D3508-7F BENDING DETAIL
(MAKE FROM D3508-7F)



D3508-9F BENDING DETAIL
(MAKE FROM D3508-9F)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65791

REV.	DESCRIPTION	BY	DATE
C	ADD -9/-11/-13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT	PH	07.04.20
B	CHANGE STAINLESS STEEL, WIDEN	PH	06.10.27
A	NEW ISSUE	PH	06.04.21

DESIGN		DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3508	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	1:8
DATE	07.04.20		

8/11-01-7

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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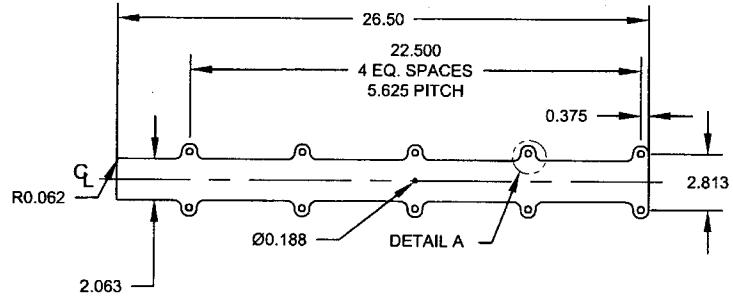
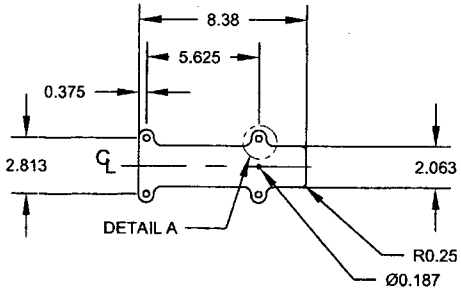
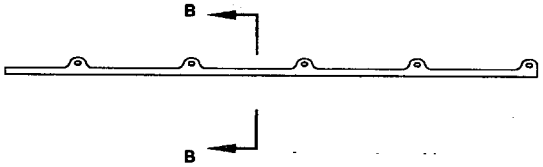


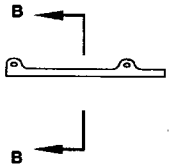
D3508-11F FLAT PATTERN



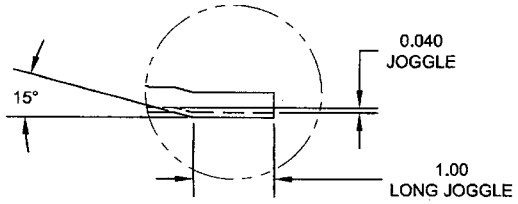
D3508-13F FLAT PATTERN



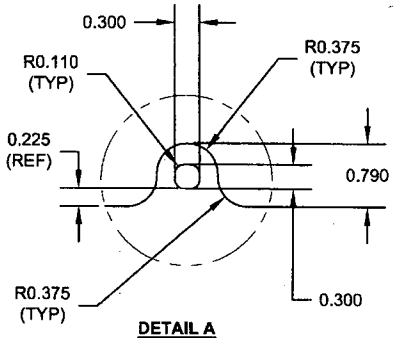
D3508-11 BENDING DETAIL
(MAKE FROM D3508-11F)



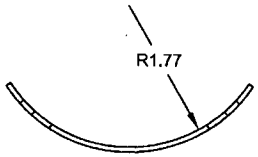
D3508-13 BENDING DETAIL
(MAKE FROM D3508-13F)



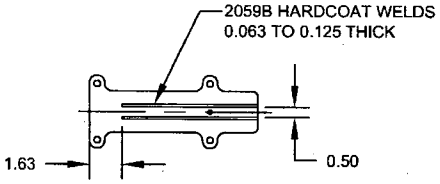
DETAIL C
(SCALE 1:2)



DETAIL A
(SCALE 2:3)



SECTION B-B
(SCALE 2:3)



D3508-13 WELDING DETAIL

W/065191

RELEASED
07-11-20

DESIGN	PH	**DART AEROSPACE USA, INC** PORT HADLOCK, WA
DRAWN	PH	
CHECKED		DRAWING NO. D3508 — REV. C — SHEET 2 OF 2
MFG. APPR.		
APPROVED		TITLE WEARPLATE — SCALE 1:6
DE APPR.		
DATE	07.04.20	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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